

Work Order ID 60624

Thursday, July 15, 2010 10:28:26 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: 

Date: 7-15-10 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: H108775 0.00
Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

10.01.22

10.07.23

W/O:		WORK ORDER CHANGES						
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Process Plan:

Date:

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 9:15

Oven Temperature: 320°

Finish Time: 9:45

① BR 10-7-26

140

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

ml 10 07 26 ①

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Picklist Print

Thursday, July 15, 2010 10:28:30 AM

Page 1

Work Order ID: 60624

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)


Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	13.0000	2	2			

Location

Loc Qty

Loc Code

WA

13

46086

2

51745

1

57185

1

* 59265

9

D3914-1



Rib

Manufactured

No

100

Each

6.0000

2

②

2

Location

Loc Qty

Loc Code

WA

6

59295

2

59926

4

D3914-7



Rib

Manufactured

No

100

Each

6.0000

2

②

2

Location

Loc Qty

Loc Code

WA

6

59095

2

* 59986

4

①

①

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Page 2

Work Order ID: 60624

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No 100 Each 7.0000 3 3



Hinge Half, Lid

Location

Loc Qty

Loc Code

WA

7

58737

1

59744

6

D4018-5 Manufactured No 100 Each 48.0000 9 9



Rib

Location

Loc Qty

Loc Code

WA

48

58669

12

59929

36

D4020-5 Manufactured No 100 Each 2.0000 1 1



Mesh (350 Basket Long, Lid)

Location

Loc Qty

Loc Code

WA

2

59601

2

D4021-3 Manufactured No 100 Each 4.0000 1 1



Data Plate

Location

Loc Qty

Loc Code

WA

4

56050

1

59054

1

59987

2

RD 10.07.20
B60543-2

RD 10.07.20

RD 10.07.21
B60643-1

RD 10.07.20
B60547-1

Thursday, July 15, 2010 10:28:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Page 3

Work Order ID: 60624

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100 Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA

3

59414

1

60045

2

D4035-043

Manufactured No

100 Each

3.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

3

59415

1

60047

2

D2728-3

Manufactured No

140 Each

0.0000

1

1



Dart Logo label

D4086-210

Manufactured No

140 Each

9.0000

1

1



Placard, Max Load

Location

Loc Qty

Loc Code

ST117

9

58926

9

10.07.20

10.07.20

8/10/07/27

8/10/07/27

356978 (12)

Thursday, July 15, 2010 10:28:30 AM

Shop Packet Print

Page 3

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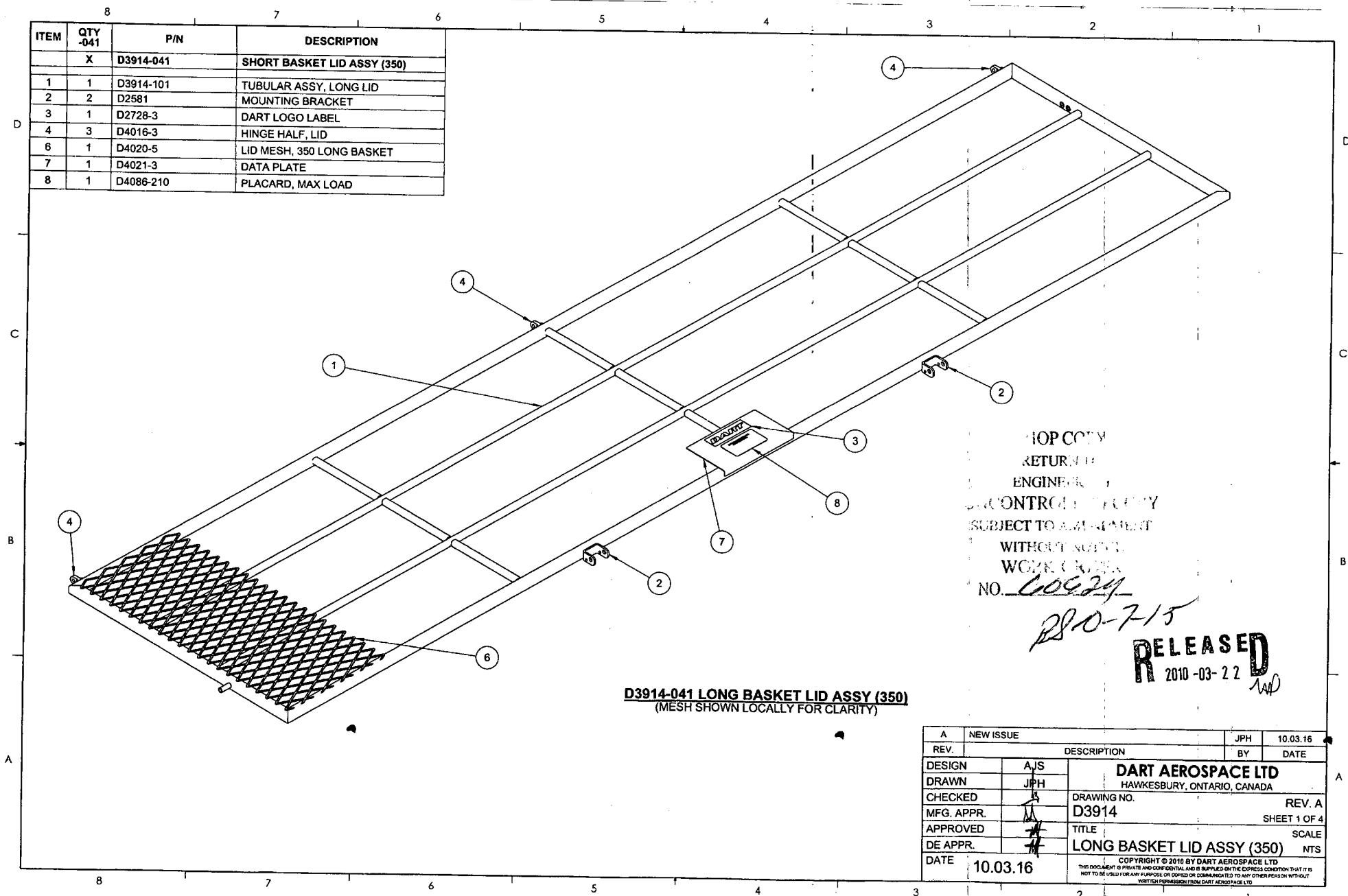
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

TOP COPY
RETURNED
ENGINEER
CONTROL COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK ORDER
NO. 60424

28-0-7-15

RELEASED
R 2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

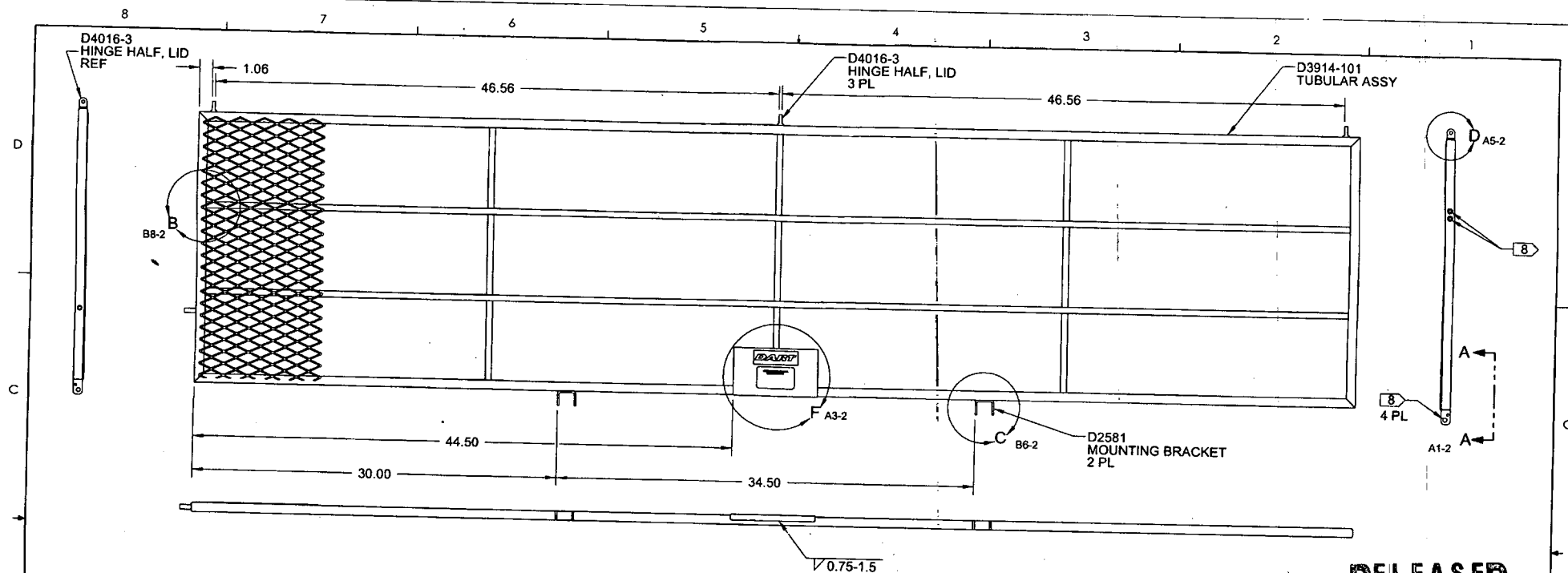
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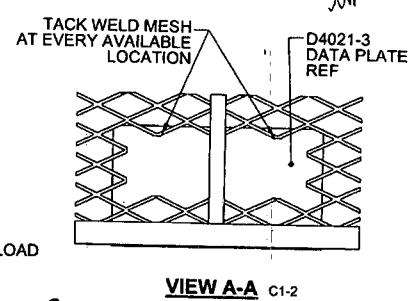
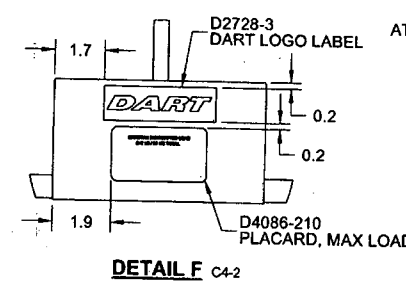
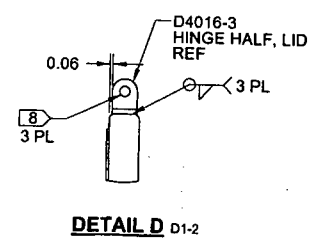
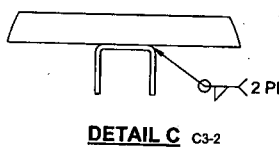
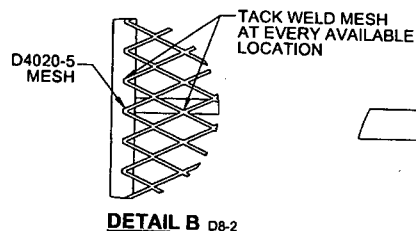
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-22



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.35 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

Whitney

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3914	SHEET 2 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET LID ASSY (350)	NTS
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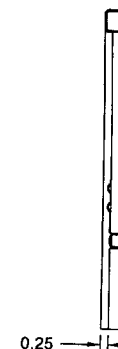
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

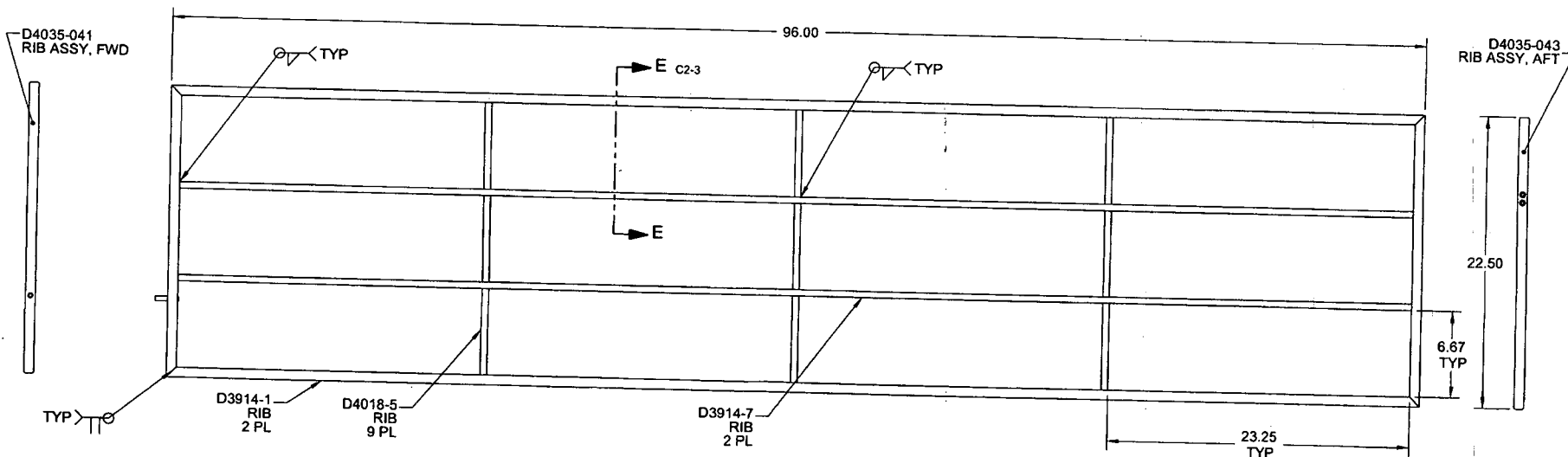
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
2010-03-22

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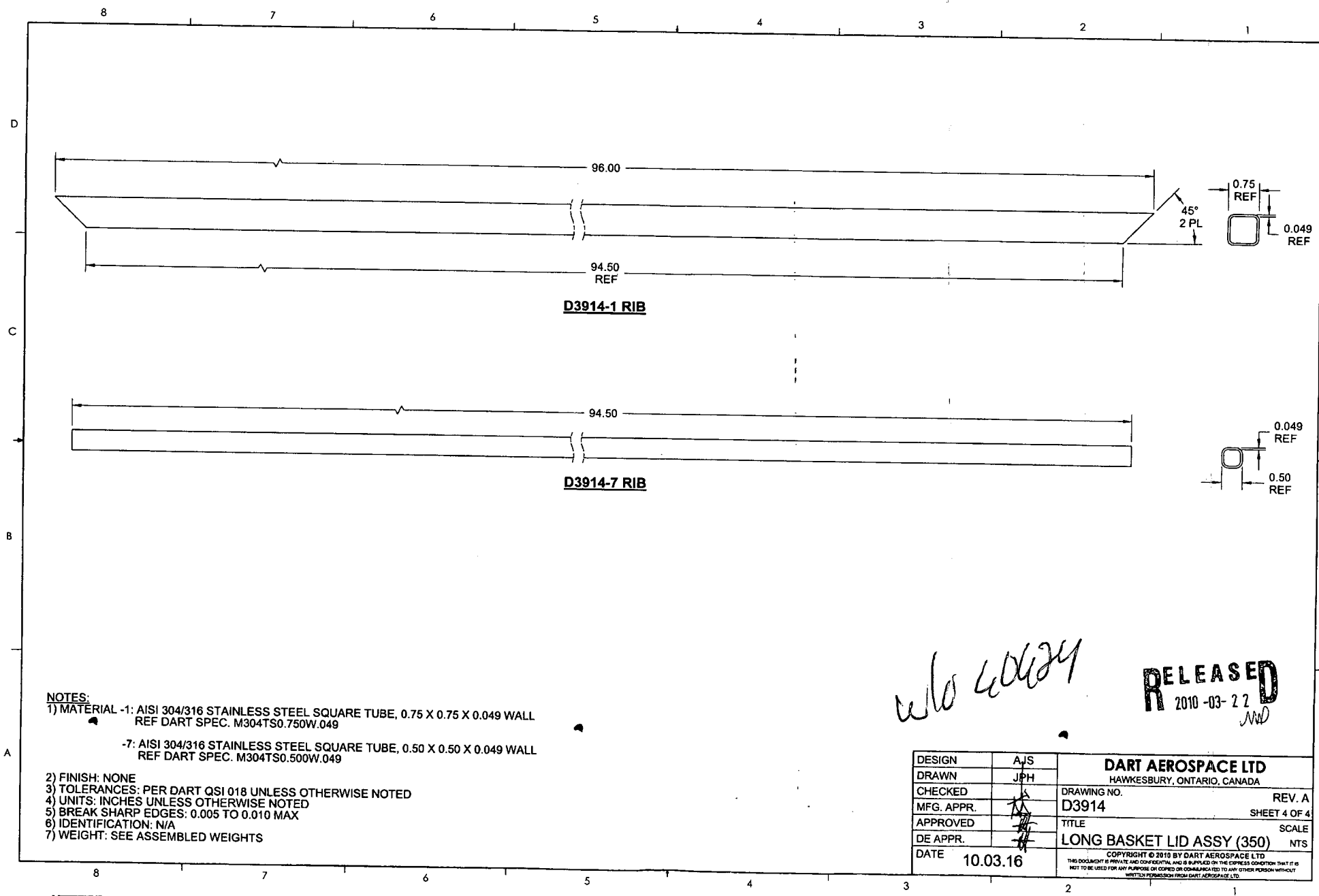
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